

Abstract

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[illegible]

Stop



1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves assessing the outcomes against the objectives and goals and identifying any areas for improvement.

Customer:

Required Date: 5/18/2011 **Req'd Qty:** 20.00

Reference:



Date:

Date:

Stop

[illegible]

Draw Nbr	Revision Nbr	
D2873	Rev A	

0.00

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the work.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete them.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress to ensure that the objectives are being met.

5. The final step is to evaluate the results of the project. This involves assessing the effectiveness of the plan and identifying any areas for improvement or further action.

BAND SAW

0,00

Bandsaw

Memo

Jeaspa Bandsaw

Cut blanks: 1.000" x 0.375" x 3.700" long

0.00

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

Machine as per Folio FA and Dwg D2873 ☐ Identify as D2873-3
Dwg Rev A Folio Rev AA

0.00

[illegible]

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

Work Order ID 68084

Wednesday, April 06, 2011 11:30:12 AM



Page 2

Item ID: D2873-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Nut Plate Assembly

Start Date: 4/6/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/18/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

*SL**11/04/19**(20)*

Memo

0.00

140



Small Fab

Small Fab

Small Fab

Memo

1-Deburr □2- C'sink as per Dwg D2873

0.00

0.00

EB/04/19 (20)

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

*S 11/04/19**Counter (20)*

Memo

0.00

Work Order ID 68084

Wednesday, April 06, 2011 11:30:12 AM



Page 3

Item ID: D2873-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Nut Plate Assembly

Start Date: 4/6/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/18/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

20 0 11 11/04/20

170



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

20 BR 11-4-20

180



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1-Assemble as per Dwg D2873 ☐ 2-Identify as D2873-043

20 54/04/25 (20)

Work Order ID 68084

Wednesday, April 06, 2011 11:30:12 AM



Page 4

Item ID: D2873-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Nut Plate Assembly

Start Date: 4/6/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 5/18/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				count x20			
200 Packaging Packaging	Identify as per dwg & Stock Location: <u>x-tube</u> <u>Ass'y</u> Memo	0.00 0.00							
210 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

11 - 04 - 28 (20)

11/4/29 (20)

Picklist Print

Wednesday, April 06, 2011 11:30:17 AM

Page 1

Work Order ID: 68084

Parent Item: D2873-043

Parent Item Name: Nut Plate Assembly




Start Date: 4/6/2011

Required Date: 5/18/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A ☐ 05.09.13 ☐ New issue ☐ KJ/JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21075L5  Nut Plate		Purchased	No			100	Each	86.0000	3	60			
<div> <div>Location</div> <div>ST303</div> <div>116914</div> </div> <div> <div>Loc Qty</div> <div>86</div> <div>86</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
M6061T6B0.375X01.00 0  6061T6 BAR .375 x 1.00		Purchased	No			180	f	25.1336	0.3083	6.490526			
<div> <div>Location</div> <div>MAT002</div> <div>116963</div> </div> <div> <div>Loc Qty</div> <div>25.1336</div> <div>25.1336</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
MS20426AD4-6  Rivet		Purchased	No			180	Each	1,396.000	6	120			
<div> <div>Location</div> <div>ST317</div> <div>110139</div> </div> <div> <div>Loc Qty</div> <div>1396</div> <div>1396</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

Handwritten notes and signatures:

- 45* (under Total Qty for M6061T6B0.375X01.00)
- MI17505 (152)* (next to M6061T6B0.375X01.00)
- 6.49* (under Total Qty for MS20426AD4-6)
- 120* (under Total Qty for MS20426AD4-6)
- 4/5/04/25* (signature over MS21075L5)
- 4/5/04/25* (signature over MS20426AD4-6)

DART AEROSPACE LTD		Work Order:	68084
Description: Radius Block		Part Number:	D2873-3
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.500	✓		Vern	GA-01
2.000	+/-0.010	2.000	✓		"	"
0.750	+/-0.010	0.751	✓		"	"
1.000	+/-0.010	1.000	✓		"	"
0.250	+/-0.010	0.250	✓		"	"
1.000	+/-0.010	1.000	✓		"	"
2.000	+/-0.010	2.000	✓		"	"
3.000	+/-0.010	3.000	✓		"	"
Ø0.128	+0.005/-0.001	Ø0.133	✓		"	"
0.359	+/-0.010	0.359	✓		"	"
Ø0.316	+0.006/-0.001	Ø0.318	✓		"	"
1.000	+/-0.010	1.006	✓		"	"
0.250	+/-0.010	0.252	✓		"	"
0.061	+/-0.010	0.062	✓		"	"
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	Ø0.231 x 0.125	✓		"	"

Measured by: GA	Audited by: SL	Prototype Approval:	N/A
Date: 11/04/15	Date: 11/04/19	Date:	N/A

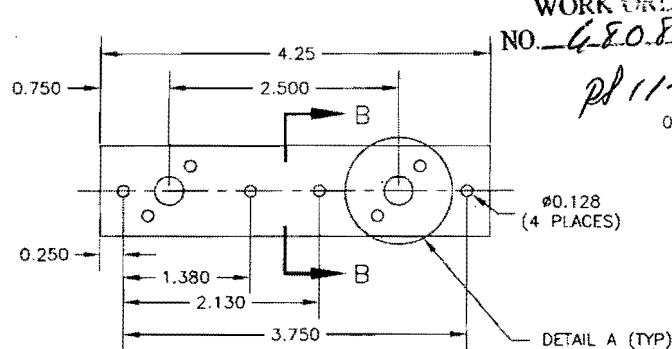
Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	<i>[Signature]</i>

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

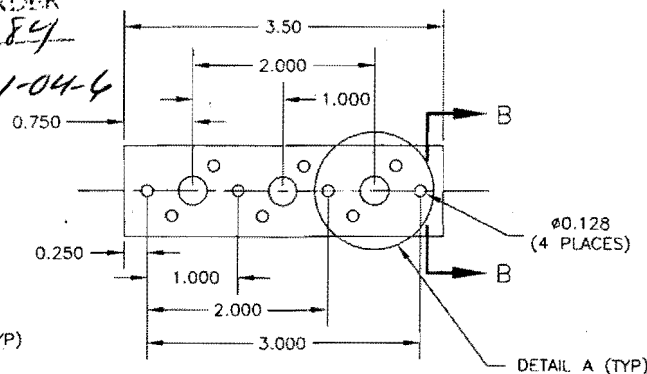
WITHOUT NOTICE
WORK ORDER

NO. 68084

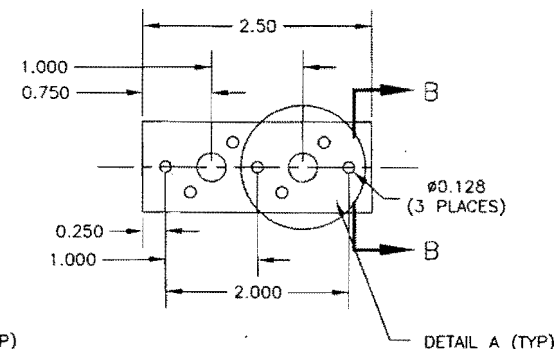
PR 11-04-4



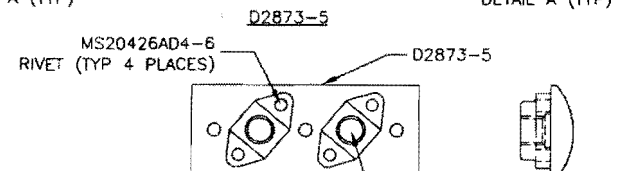
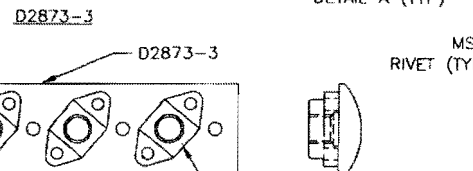
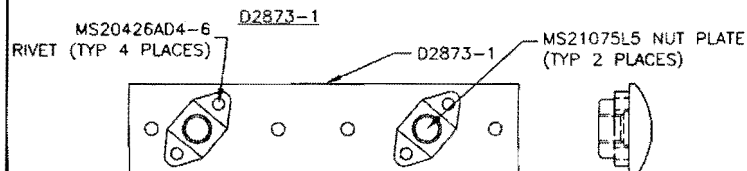
DETAIL A (TYP)



DETAIL A (TYP)



DETAIL A (TYP)



D2873-041

MS20426AD4-6 RIVET (TYP 6 PLACES)

D2873-043

MS21075L5 NUT PLATE (TYP 3 PLACES)

D2873-045

MS21075L5 NUT PLATE (TYP 2 PLACES)

D2873-1/-3/-5 RADIUS BLOCK

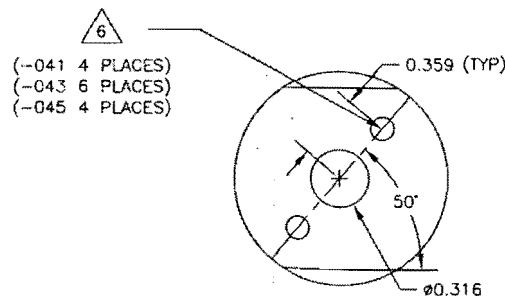
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100'

D2873-041/-043/-045 NUT PLATE ASSEMBLY

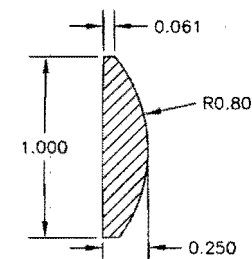
- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



DETAIL A (SCALE 2:5)



SECTION B-B (SCALE 2:5)

RELEASED
05.07.26

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD WARRICKSBURY, OXFORD, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873 REV. A SHEET 1 OF 1
DATE 05.07.26	TITLE RADIUS BLOCK	SCALE 4:5